

Work Order ID 63448

Tuesday, November 02, 2010 9:21:29 AM



Page 1

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Stop



Start Date: 11/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

10-11-02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	C								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4148								
	Prog Rev: <u>E</u>								
	Dwg Rev: <u>C</u>								
	Deburr as required								
110		0.00							
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo								

B10-11-2

(5)

B10-11-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4148-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Plate, Fwd

Start Date: 11/2/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



8/10/10/03

25

Subline
133

10/11/09

10/11/09

MF
10-11-9

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Picklist Print

Tuesday, November 02, 2010 9:21:33 AM

Page 1

Work Order ID: 63448



Parent Item: D4148-1

Parent Item Name: Crosscube Lug Plate, Fwd

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	43.8523	0.3607	1.518737			



304/316 0.125 Sheet



1810-11-1

Location

Loc Qty

Loc Code

MAT

43.8523

114799

43.8523

114799



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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63448
Description: CROSS-TUBE Lug PLATE FWD		Part Number: D4148-1
Inspection Dwg: D4148-1 Rev: C		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

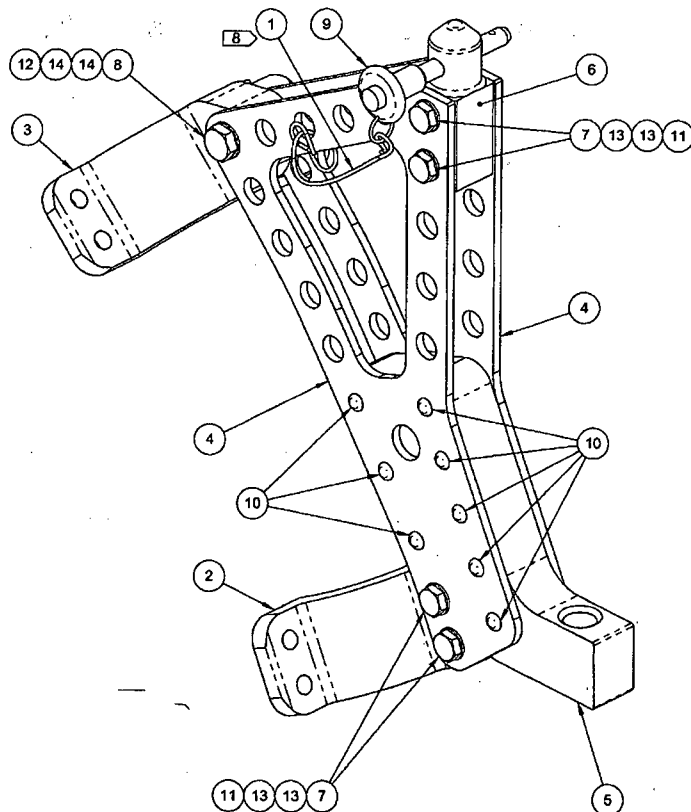
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.134	*		V ISO2	
Ø .191	+ .005 - .001	.196	✓		V	
Ø .38	+ .006 - .001	.379	*		V	
Ø .257	+ .006 - .001	.259	✓		V	
Ø .50	+ .006 - .001	.503	*		V	
.94	± .030	.934	*		V	
4.47	± .030	4.477	x		V	
.750	± .010	.764	✓		V	
8.47	± .030	8.478	✓		V PRO ISO2	
8.096	± .010	8.098	✓		V PRO ISO2	
5.43	± .030	5.435	✓		V	
5.197	± .010	5.197	✓		V	
4.733	± .010	4.730	✓		V	
.310	± .010	.310	✓		V	
.750	± .010	.750	✓		V	
.375	± .010	.376	✓		V	
1.84	± .030	1.838	✓		V	
Pitch .92	± .030	.919	✓		V	
3.006	± .010	2.997	*		V	
Pitch .750	± .010	.749	✓		V	
.625	± .010	.623	*		V	
1.982	± .010	1.984	*		V	
Pitch .991	± .010	.992	✓		V	

Measured by: MB
Date: 10-11-2

Audited by: S
Date: 10/4/13

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63445

PD 10-11-02

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

RELEASED
2010-10-28

C	REDESIGNED D4148-1A-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-501 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN CB-5) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. C
SHEET 1 OF 5

TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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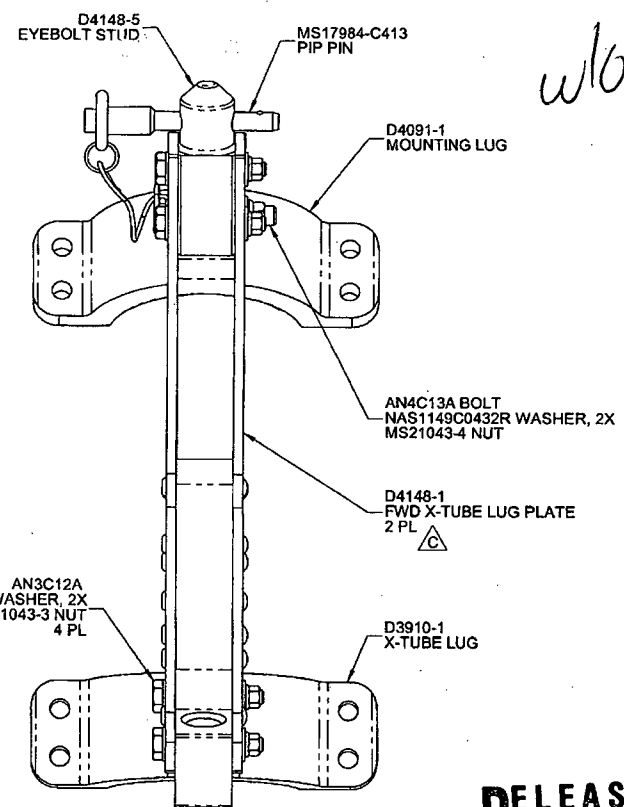
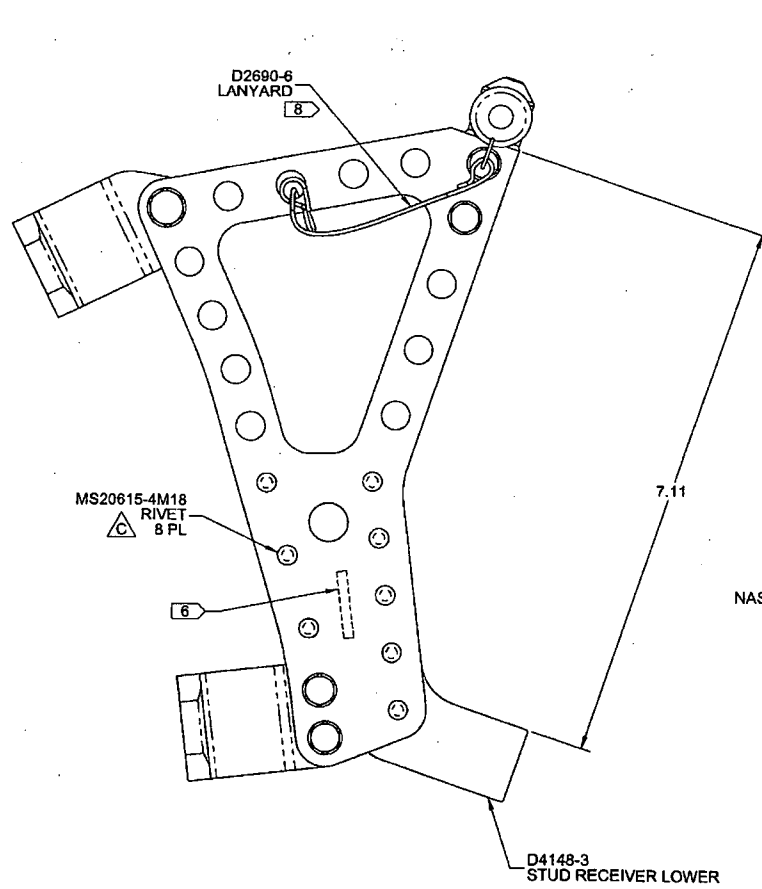
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



W10 634118

D4148-041 FWD X-TUBE LUG ASSY

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2010-10-28

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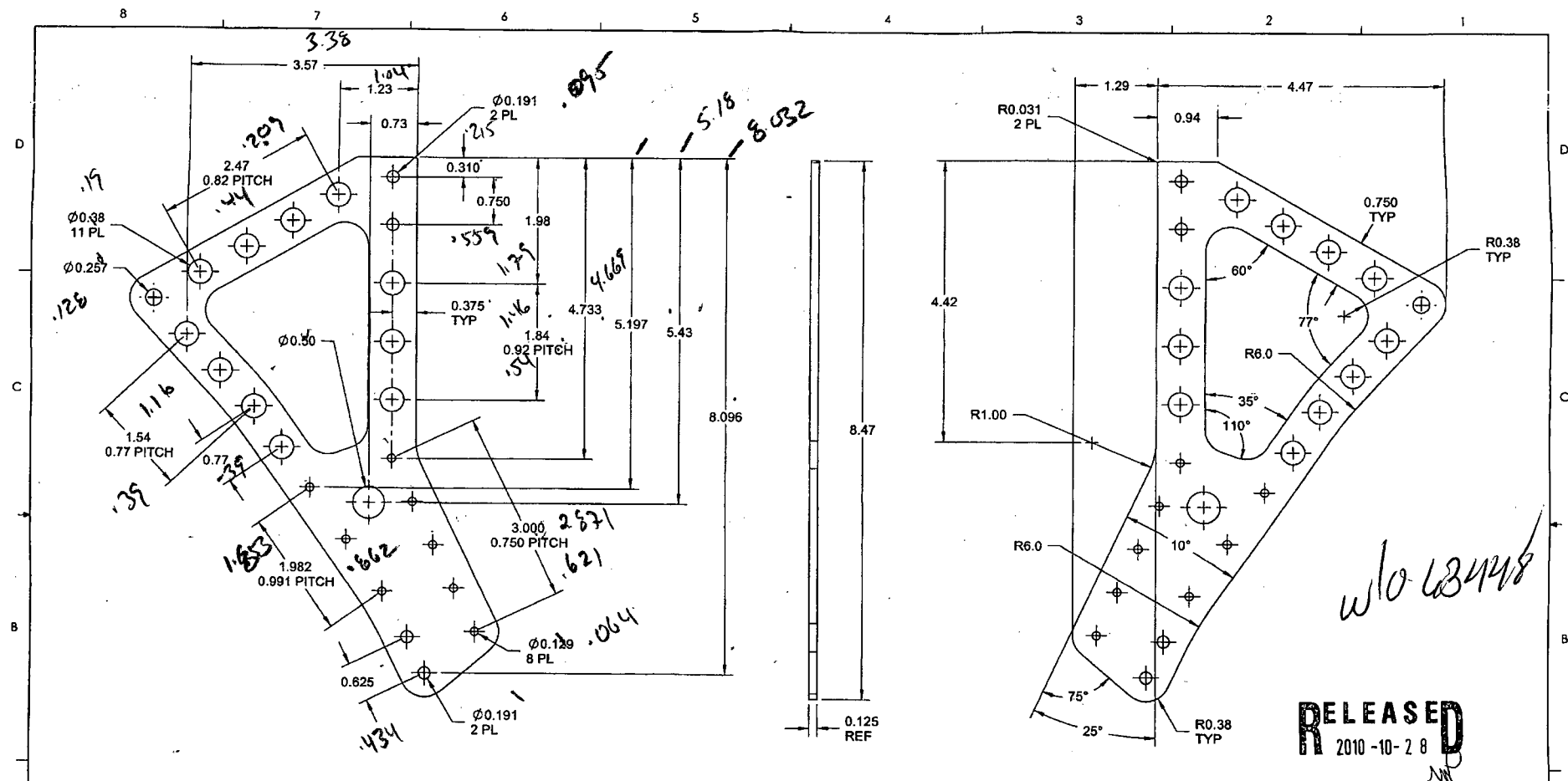
Dart Aerospace Ltd

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D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

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MFG. APPR.		D4148	SHEET 3 OF 5
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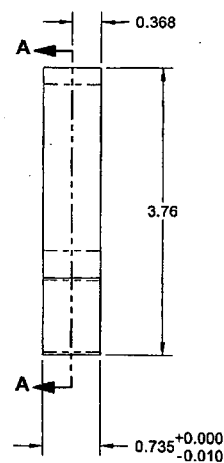
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Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and tolerances.

Key dimensions and features:

- Overall width: 4.65
- Base thickness: 0.80
- Slot width: 0.250
- Slot depth: 0.453 ± 0.010 / -0.000
- Radius of slot: R0.250
- Radius of base: R0.031 2 PL
- Radius of hatched area: R6.0
- Angle of hatched area: 65°
- Angle of base: 90°
- Angle of base: 6°
- Angle of hatched area: 9°
- Hatched area label: R0.3 TYP
- Hatched area label: 0.06 X 45° CMF
- Other dimensions: 2.12, 0.59, 0.89, 0.625, 1.97, 2.74, 3.27

Isometric view of a mechanical part. It features a curved flange with a circular hole and several smaller holes. A dashed line indicates a hidden edge. The part is labeled with a radius of R0.38.

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2010-10-28

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO.	REV. C
CHECKED			D4148	SHEET 4 OF 6
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APPROVED			FWD X-TUBE LUG ASSY	NTS
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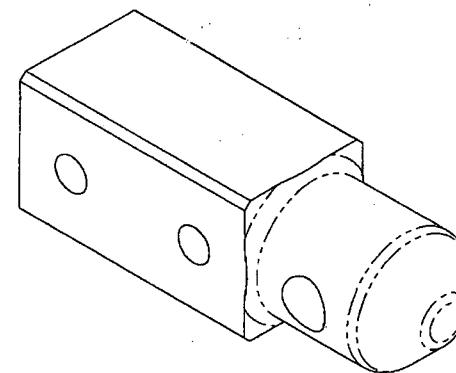
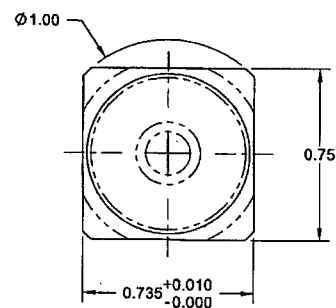
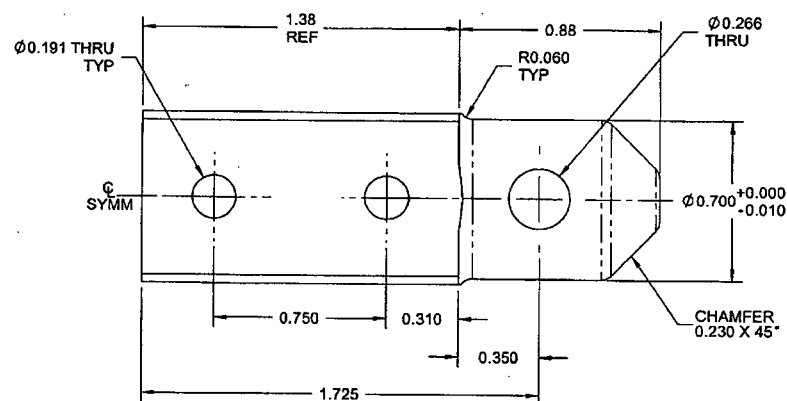
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D4148-5 EYEBOLT STUD

w/b 63 446

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2010-10-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

DESIGN		DART AEROSPACE LTD	
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